1258

QC

Quality Control

Memo

									•	DQA:	Date:	
NCR: Y	es / No			4	WORK ORDER NON-	CON	IFORM	MANCE / UP	DATE			
	W-51-44									QA Closed:	Date:	
Work Orde	eř:				DISPOSITION				AGAINST DE	EPARTMENT	/PROCESS	
Part N NCR N	lo.				Rework Scrap Use-as-is Work Order Update		ı	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	-	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
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Root				Descri	ption of work order update	li	nitial	Act	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chi	ief Eng	Desc	ription	Date	Verification	QC Inspector
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Supplier												
Training												
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	Crushed/	Crimped			Burrs	\vdash		ions Incomplete/	Unclear	Part Lost/Mi	issing	Wrong Stock Pulled
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	Inspectio	-	Tube	<u></u>	Cut Too Short		Misread	I	L	Power Loss/	Surge	Other
·	Ripples in			<u></u>	Drill Holes	\vdash	Offset					
	Torque W	Vaves in E	extrusion	ո	Drawing		Out of 0	Calibration				
	Turning S	Companie		1	Einich	1 1	Out of	Saguence				i

Outside Dimensions

Wave/Twist in Tube

Work Ord <i>May 8, 2013 7:</i>		01346		<u>**</u> *10	1346*					Page 2
Item ID: Revision ID:	D4021-3			Accept	*N900040	100*	Setup	Start	*N.S	31*
Item Name:	Data Plate							Stop	*NS	32*
Start Date: Required Date: Reference:	5/08/13 : 5/10/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* (*4* `	5 Col	Cust Item ID: Customer:		•			
Approvals:	Process Pl	an:	_ Date:	Tooling:	Date:	-	Run	Start	*NF	₹1*
			· · · · · · · · · · · · · · · · · · ·	-	Date:		, ÷.	Stop	*NF	?2*
Sequence ID/ Work Center 1		Operation Description		Set Up/ Run Hours	in the second of	Plan Acce Code Qty			Reject	Insp. Stamp
130 Brake NC		Bend as per dwg Memo	٠.	0.00		54				13lo51
¹⁴⁰ *1 ⊿∩ *		QC5- Inspect part compl	leteness to step on W/O))(13.5.7	54				
QC Quality Control		Memo		0.00	1× ³		· · ·			
*150		Identify as per dwg & St	ock Location: WA	(_,	γ (13.5.9	54				
Packaging		Memo		0.00	,					

Packaging

NCR:	Yes	/	No
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NCR: Ye	es / No				WORK ORDER NON- 0	CONF	ORN	MANCE / UPI	DATE			
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Work Order	÷				DISPOSITION					EPARTMENT,		
Part No	D				Rework Scrap Use-as-is		ſ	Skid-tube Machining noforming	Crosstube Small Fab Finishing	┥	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR No	o				Work Order Update]		Large Fab	Composite]	Supplier	
Root				Descri	ption of work order update	Init	tial	Act	ion	Sign &		
Cause	Date	Step	Qty	•	or Non-conformance	Chie	f Eng	Descr	ription	Date	Verification	n QC Inspector
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	Bending			_	Bend		rain	·		Ovalized		Pressure/Forced
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L	Cuffs			<u> </u>	Contamination	∐м	/lainte	nance		Part Moved		
L	Heat Trea	at		<u> </u>	Countersink	Шм	1islabe	led	_	Positioned V		
	Inspection	n Strip in	Tube	_	Cut Too Short	Шм	1isreac	I		Power Loss/	Surge	Other
	Ripples in	Bend			Drill Holes		ffset					<u> </u>
. [Torque W	/aves in E	xtrusio	n _	Drawing	0	ut of C	Calibration				
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Date:

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Work Ord <i>May 8, 2013 7.</i>		01346		<u>*</u> *101	1346*							Page 3
Item ID: Revision ID: Item Name:	D4021-3 Data Plate			Accept	*N900	<u>040</u>	100)*	Setup	Start Stop	ı Vi,	S1* S2*
Start Date: Required Date Reference:	5/08/13 : 5/10/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item 1 Customer:	D:						
Approvals:	Process P	lan:	Date:	Tooling:	D	ate:	_]	Run	Start	*N	R1*
	QC:	· •-··-	Date:	SPC (Y/N):	D	ate:				Stop	*N	R2*
Sequence ID/ Wo. k Center I	D	Operation Description QC21- Final Inspection	- Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Re Qt	•	Reject Number	Insp. Stamp
160 QC Quality Control		Memo		0.00				_ML	5	13-0)S-10	>

MCJ 13 C5-10

⁄es	/ No				WORK ORDER NON-O	100	NFORM	MANCE / UP	DATE	QA Closed:	Date:	
er:		Y			DISPOSITION	1				PARTMENT	_	
No					Rework Scrap Use-as-is Work Order Update		Thern	Machining noforming	Crosstube Small Fab Finishing Composite	-1	d. Eng. Coor.	Engineering Quality Other
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	Date	Step	diy	·	or Non-comormance		ici ciig	<i>Description</i>	iption			QCspecto.
					F	AUL	T CATE	GORY				
	Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspectio Ripples in Torque V	Crimped at n Strip in n Bend Vaves in E	Tube Extrusio		General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Hardwa Inspecti Instruct Mainte Mislabe Misread Offset Out of 0	re ion Incomplete ions Incomplete/lenance eled d	Jnclear	Part Incorre Part Lost/M Part Moved Positioned V	ct sissing	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
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Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

May 8, 2013 7:09:45 AM

Work Order ID:

101346

Parent Item:

D4021-3

Parent Item Name:

Data Plate

verified by:EC

Start Date: 5/08/13

Required Date: 5/10/13

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP RevA: new issue DD 09.11.25 verified by:EC

IPP RevB: new part DD 09.12.03

IPP Rev:C as per dwg REV.A DD 10.02.22 verified by:EC

Rev:D as per dwg revB DD 10.04.20 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 304/316 .040 Sheet		Purchased	No			100	sf	294.6962	0.1944	0.204631	16 CC	13-5	5-8
·				Location		Lec Qty	Le	oc Code					
		•		MAT020		294 59621							

117.15 177.54621

										DQA:	Date:	
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	Cracks				Broken/Damaged		Inspect	ion Incomplete	<u> </u>	Part Incorred		Weld
	Crushed	/Crimped			Burrs		Instruct	ions Incomplete/Unclear		Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs			<u>.</u>	Contamination		Mainte	enance	L	Part Moved		
	Heat Tre	at			Countersink		Mislabe	eled	L	Positioned V	/rong	_

Misread Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Other

Power Loss/Surge

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Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

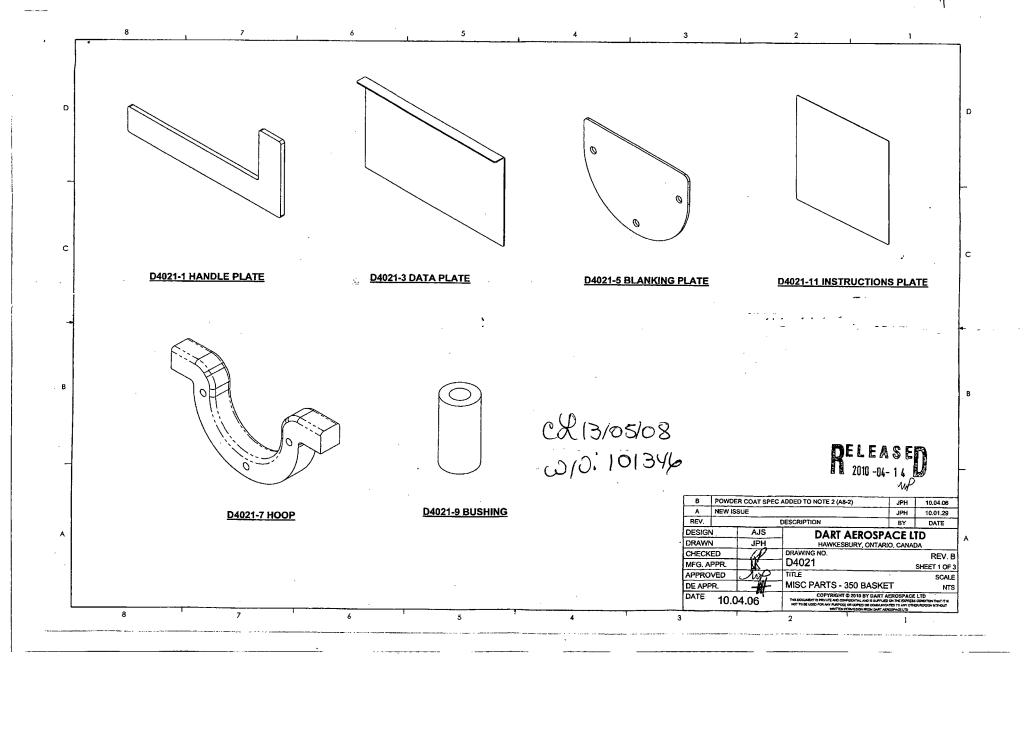
Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

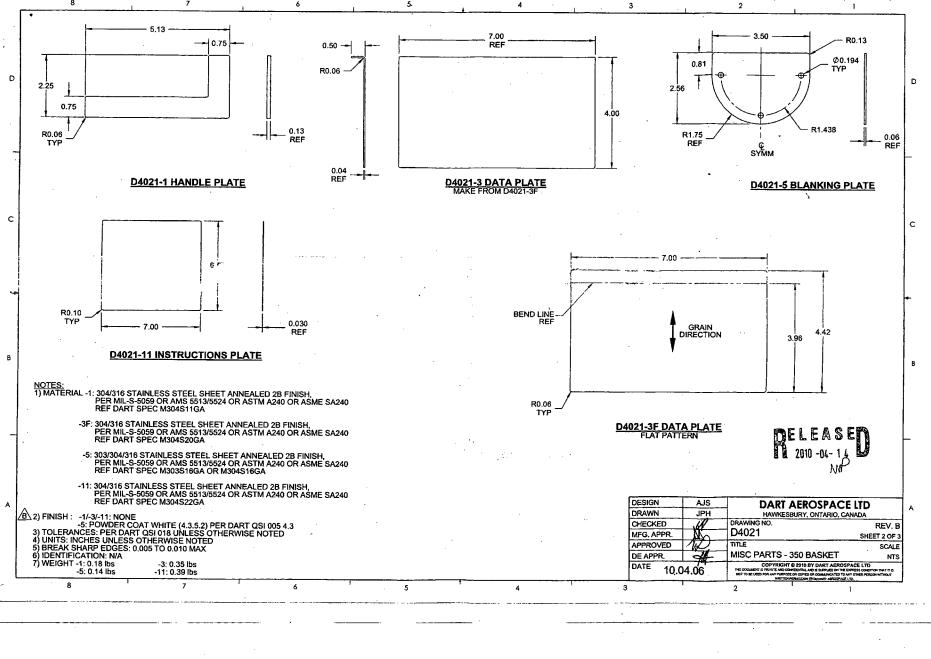
Finish



NCR:	Yes	1	No
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Date:

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Work Orde	r:				DISPOSITION				AGAINST DE	PARTMENT,	_	
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	Crushed	/Crimped			Burrs	Instru	ctions Incomplete/Uncl	lear	Part Lost/Mi	_	Wrong Stock Pulled
	Cuffs				Contamination	Main	tenance		Part Moved		
	Heat Tre	at			Countersink	Mislal	peled	į į	Positioned V	Vrong	_

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

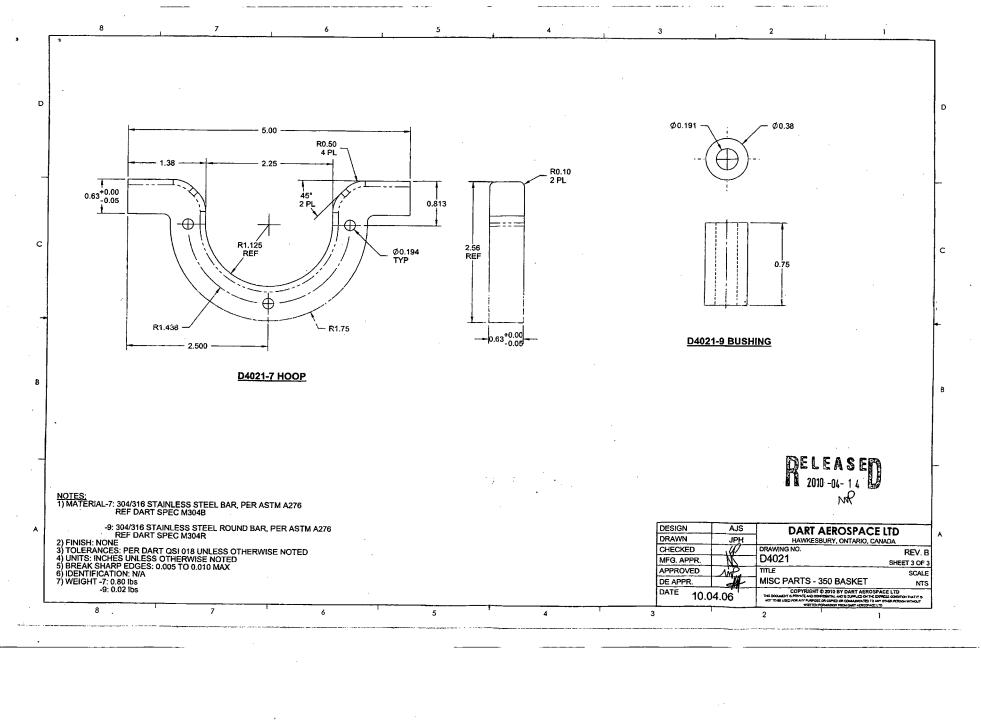
Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish



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NCR: Yes / No	NCR:	Yes	/	No
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			•		,	4				•		DQA:	Date:		
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Part No. NCR No.							Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Composite		Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier		Engineering Quality Other		
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		Inspection Strip in Tube Ripples in Bend					Drill Holes		Offset						
		Torque Waves in Extrusion Turning Sequence					4 ° H			Out of Calibration Out of Sequence					

Outside Dimensions

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Wave/Twist in Tube